

Date: Friday, 01/08/2008 3:31:23 PM
 User: Julie Lecocq

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: END FITTING ASS'Y		
Job Number	: 40950					
Estimate Number	: 13345					
P.O. Number	:			Part Number	: D3763041	
This Issue	: 01/08/2008		S.O. No. :	Drawing Number	: D3763 REV B	
Prsht Rev.	: NC			Project Number	: N/A	
First Issue	: / /		Type :	Drawing Revision	: B	
Previous Run	: 40684			Material	:	
Written By	:			Due Date	: 21/08/2008	
Checked & Approved By	<u>JLD 08.8.05</u>			Qty:	10	Um: Each
Comment	: Est Rev:A 08-05-20 new issue DD verified by:ec					
	Est Rev:B 08-07-18 revB as per dwg DD verified by:EC					

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	PACKAGING 1	PACKAGING RESOURCE #1
Comment: PACKAGING RESOURCE #1 Pick Packing Kit		
2.0	D37631	End Fitting
Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s) End Fitting batch: <u>B40994 = 4</u> <u>B4315 = 4</u> <u>SP 08.12.04</u> <u>310995-1</u>		
3.0	D37633	Tube
Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s) Tube batch: <u>340995</u> <u>SP 08.12.04</u>		
4.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
Comment: LARGE FABRICATION RESOURCE 1 1-make a 0.063" chamfer on D3763-1 fitting before ass'y 2-assemble as per dwg D3763 using locating pin DT <u>9037</u> 3-weld as per dwg D3763 QSI004 Alum. rod Batch: <u>M104855</u> <u>SP 08.12.04.</u> <u>(10x)</u>		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 01/08/2008 3:31:23 PM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: END FITTING ASS'Y

Job Number: 40950

Part Number: D3763041

Job Number:



Seq. #: Machine Or Operation:

Description :

5.0 QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

Op 08/12/04 BE 08/12/05 (10k)

6.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Satisfied (10)

7.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify with Dart part # using a fine point permanent marker and Stock
Location: ST24P

AS 08/12/11 (10)

8.0 QC21

FINAL INSPECTION/W/O RELEASE



08/12/11 (10)

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 08/12/11

WO:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
8/12/05	6.1 6.2	<p><i>Permit change</i></p> <p>ADD steps for chemical wash per QSI 2005</p> <p>ADD step for QC3 inspection</p>	<p>SS</p> <p>MM</p>	<p>08.12.09</p> <p>08/12/09</p>	10		<p>S</p> <p>8/12/05</p>
		<p>- Acid etch and ultradine per QSI 2005 4.1</p> <p>- QC3 inspect chemical wash.</p>	<p>SS</p> <p>MM</p>	<p>08.12.09</p> <p>08/12/09</p>	10		<p>S</p> <p>8/12/05</p>

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

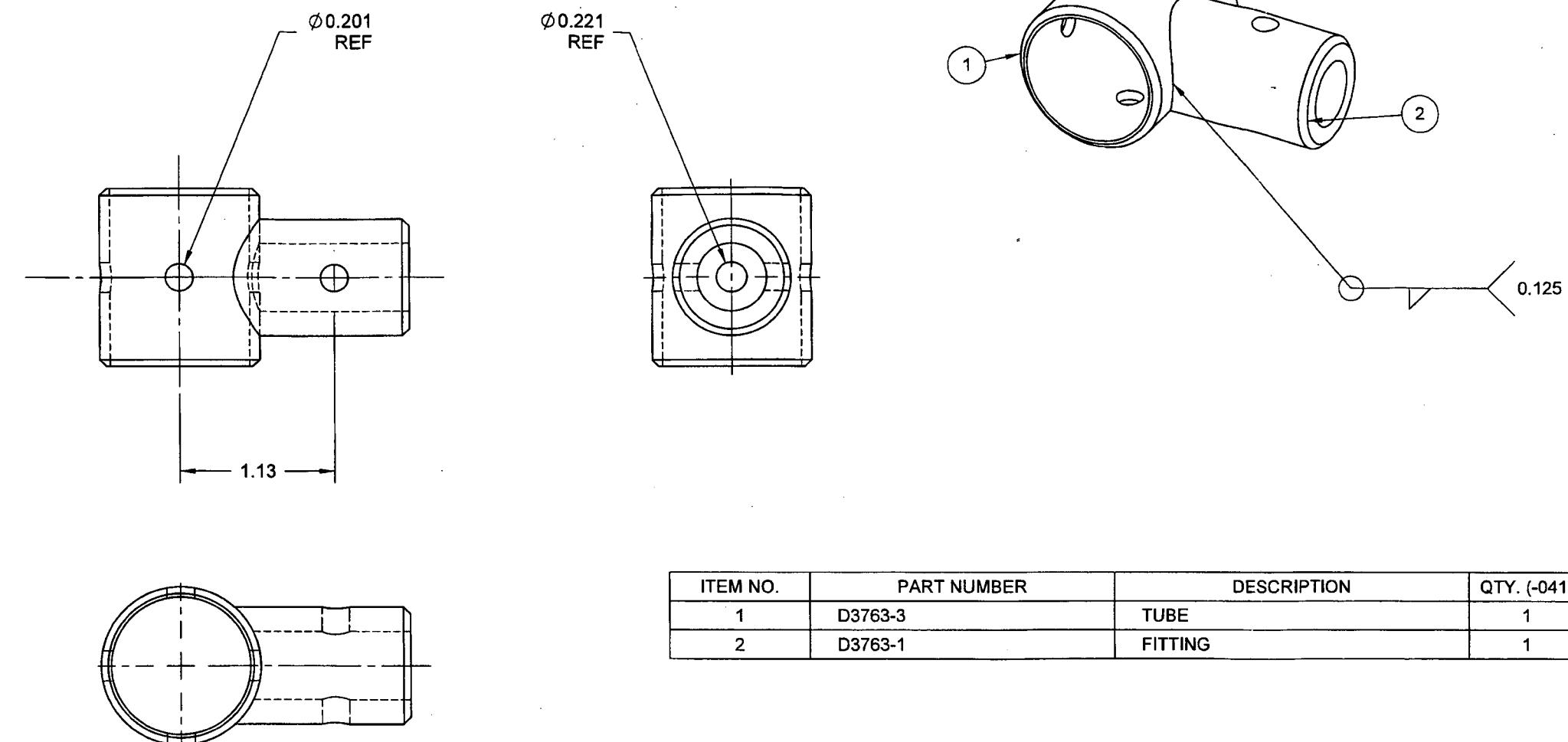
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

8 7 6 5 4 3 2 1

D

D



D3763-041 END FITTING ASSY

A

A

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: CHEMICAL CONVERSION COAT ASSEMBLY PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.03 lbs
- 8) WELD: PER DART QSI 004

B	CHANGE HOLES SIZE, ADD -7 PART AND -045 ASSY		HS	08.06.23			
A	NEW ISSUE		HS	08.06.04			
REV.	DESCRIPTION			BY DATE			
DESIGN	HS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA					
DRAWN	HS	DRAWING NO.					
CHECKED		REV. B					
MFG. APPR.		D3763					
APPROVED		SHEET 1 OF 9					
DE APPR.		TITLE					
DATE	END FITTING						
	NTS						
	08.06.23						

COPYRIGHT © 2008 BY DART AEROSPACE LTD
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS
NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT
WRITTEN PERMISSION FROM DART AEROSPACE LTD.

B
SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 40950

RELEASED
07/10/14

8 7 6 5 4 3 2 1